

Date: Wednesday, 1/25/2006 1:20:16 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services		<b>Drawing Name</b>	: BASKET BASE ASSEMBLY (350)	
<b>Job Number:</b>	: 25614C		<b>Part Number</b>	: D2221	
<b>Estimate Number</b>	: 10189		<b>Drawing Number</b>	: D2221 REV F	
<b>P.O. Number</b>	: N/A		<b>Project Number</b>	: N/A	
<b>This Issue</b>	: 1/25/2006	<b>S.O. No.</b>	: N/A		
<b>Prsht Rev.</b>	: NC		<b>Drawing Revision</b>	: F	
<b>First Issue</b>	: N/A		<b>Material</b>	: N/A	
<b>Previous Run</b>	: 25613C		<b>Due Date</b>	: 2/20/2006	
<b>Written By</b>	: SEE COMMENT Below		<b>Qty:</b>	1	<b>Um:</b> Each
<b>Checked &amp; Approved By</b>	: JG 06.01.27				
<b>Comment</b>	: Est Rev:J 05.09.02 Added D3442-1KJ/JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D31661	Basket Hoop		
		<b>Comment:</b> Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
		4 D3166-1 RIB B25478		AA 06/02/21
2.0	D22323	Basket Hinge		
		<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
		2 D2232-3 Hinge bracket B24527		AA 06/02/21
3.0	D2325	Support Gusset (350 Bask)		
		<b>Comment:</b> Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
		4 D2325 Support Gusset B25687		AA 06/02/21
4.0	D23273	Spacer Bushing		
		<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
		2 D2327-3 Bushing B24874		AA 06/02/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/25/2006 1:20:16 PM  
User: Kirk Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 25614C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D2581 Mounting Bracket B25139

*AA 06/02/21*

6.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D3442-1 Shim B23544

*AA 06/02/21*

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 37.8000 sf(s)/Unit Total : 37.8000 sf(s)

Pick:

Qty Part Number Description Batch  
36 sf M304EX0.75-16F Expanded Metal M100071

*AA 06/02/21*

8.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing  
Batch: M100023

*AA 06/02/21*

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

*AA 06/02/27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/03/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/25/2006 1:20:16 PM  
User: Kin Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 25614C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC9/6 DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD 06-02-27

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 03 02

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M19139

Expiry date: 06-06-20

SAD 06:03:02 ①

14.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

② 06/03/06

Job Completion



U 06-03-03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS

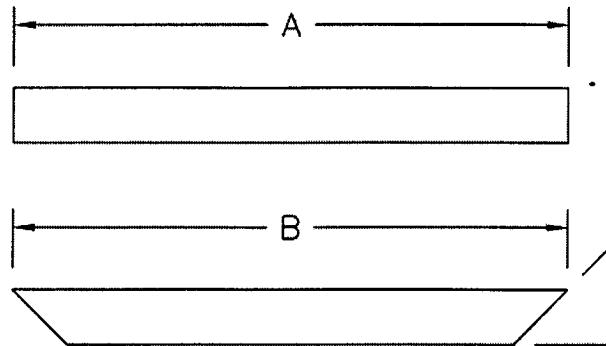
RELEASED

05.08.19 *[initials]*

C	95.11.21	SEPARATE BASKET AND LID
D	96.06.21	CHANGE LATCH
E	01.04.19	CHANGE HINGE
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO A  
WITH YOU

25614C

D2221-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

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**SKIN INSIDE SURFACE OF BASKET WITH MESH. TACK WELD EACH END OF STRAND TO FRAME**

**5** Ø0.257 (TYP 5 PLACES)  
(DRILL WHEN ASSEMBLING WITH  
D2989-041/-043 LID ONLY)

D2221-1 (2) 1.75

D2221-7

46.25

92.50

1.75 (REF)

6.50 (TYP BOTH ENDS)

D2221-5 (2)

D2221-3 (2)

TYP

25.50

18.88

55.25

18.87

30.00

34.50

30.00 (REF)

D2581 (2)

**D2232-3 (REF)**

**D3442-1 (REF)**

**D2325 (REF)**

**B**

**A**

**56.00 (REF)**

**D2221-7 (REF)**

**D2235-1**

**19.63**

**19.62**

**96.00±0.01**

**DETAIL D**

**D2232-3**

**D3442-1**

**RELEASED**

**05-08-19**

**DETAIL D**  
(SCALE 1:1)  
(TYP BOTH ENDS)

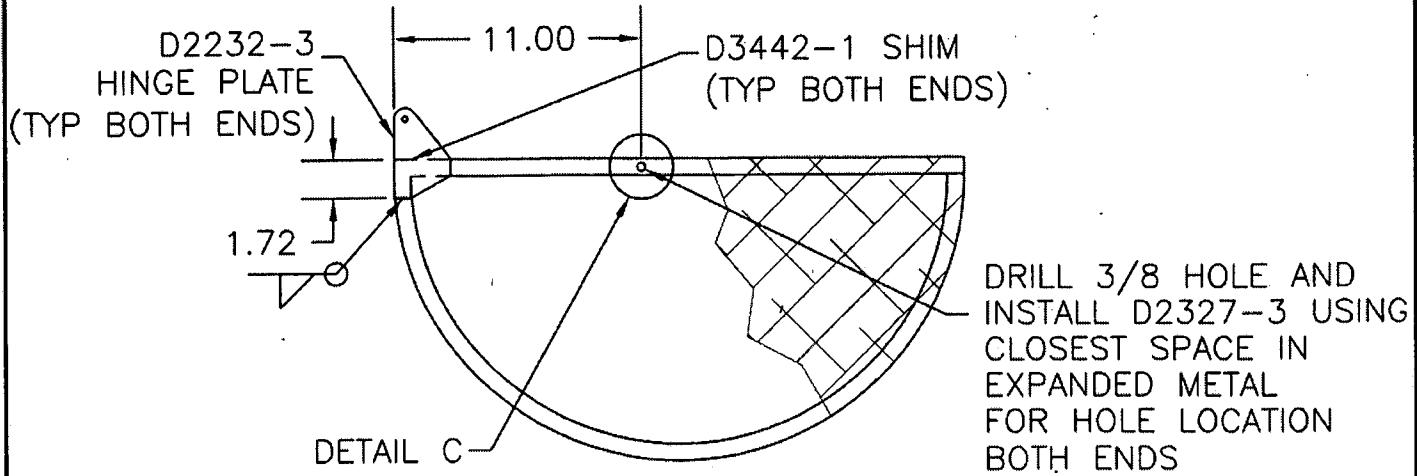
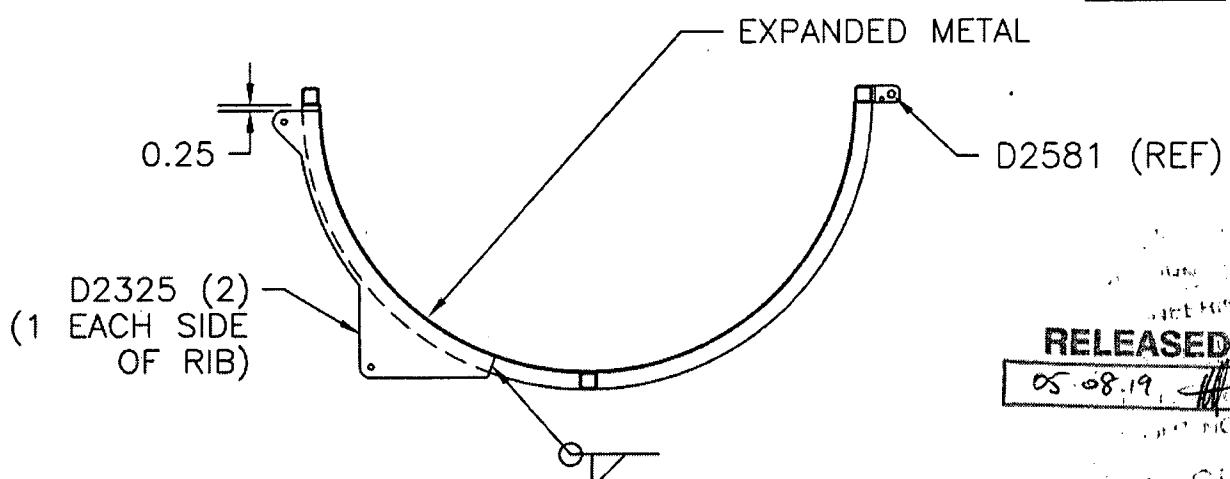
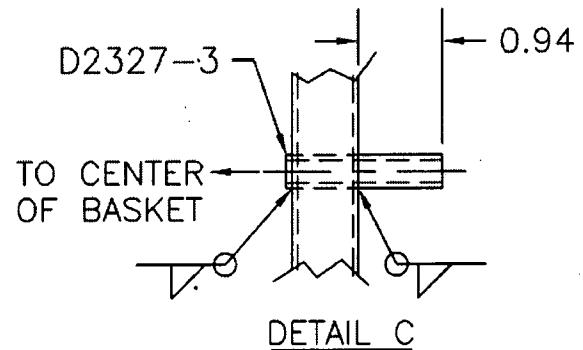
**D2221 BASKET BASE ASSEMBLY**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

		DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
DESIGN	BW	DRAWN BY	PH
CHECKED		APPROVED	
DATE	05.06.07	TITLE	BASKET BASE ASSEMBLY (350)
		DRAWING NO.	D2221
		SHEET 2 OF 3	
		SCALE	1:20

**DART**

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8

SECTION A-A SAME BOTH END RIBSSECTION B-B SAME BOTH CENTER RIBS

RELEASED  
05-08-19  
NOTICE

IN ORDER  
Z5614C

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